

Work Order ID 130681

Monday, March 23, 2015 7:33:35 AM

130681

Page 1

Item ID: D2182B060

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp Cushion

Start Date: 3/23/2015 Start Qty: 50.00

50

Cust Item ID:

Required Date: 3/23/2015 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: ML5Date: 1503-23 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2182

Rev C

100

0.00

100

Packaging

Packaging

Memo

0.00

Packaging

Cut D2182B black rubber extrusion 6.0" long

50x Sp 15-04-29.

110

0.00

110

QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

SO
DAS
27
9-03
APR 29 2015

120

0.00

120Identify as per dwg & Stock Location: PK0/6

Packaging

Memo

0.00

Packaging

50x Sp 15-04-29.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130681***130681***

Page 2

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Start Date: 3/23/2015 Start Qty: 50.00

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLJ

APR 29 2015

MLJ

APR 29 2015

DQA: _____ Date: _____



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Transport									
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Picklist Print

Monday, March 23, 2015 7:33:41 AM

Page 1

Work Order ID: 130681

130681

Parent Item: D2182B060

D2182B060

Parent Item Name: Clamp Cushion

Start Date: 3/23/2015

Required Date: 3/23/2015

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B 99.03.02 Re-format DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2182B		Manufactured	No			100	f	633.1680	0.5	25			
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D2182R

Seal(\$Per Foot)

**

Sp 15-01-29

Location

Loc Qty

Loc Code

ST411

283.168

115189

21.5

128976

261.668

st640

350

130427

350

25x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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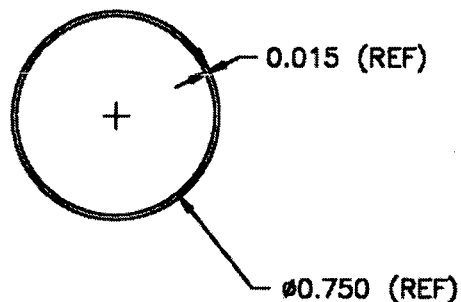
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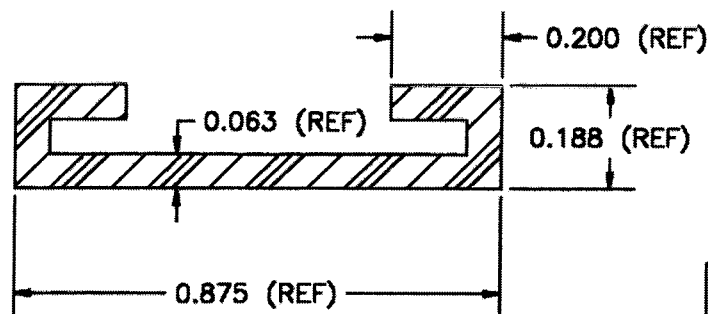
RELEASED
97/05/16 DS



D2182-050 HEAT SHRINK
LENGTH

EG: 3.5 LONG: D2182-035
10 LONG: D2182-100

MATERIAL: RAYCHEM RNF-100-3/4-CL
HEAT SHRINKABLE INSULATION SLEEVING



W-WHITE
B-BLACK
D2182W050 RUBBER CUSHION
LENGTH

EG: WHITE 3.5 LONG: D2182W035
BLACK 10 LONG: D2182B100

MATERIAL: SANTOPRENE 101-73
CONFORMS TO MIL-R-3065

130681 MLS
1503-23

DART



PREPARED <i>KE</i>		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>BS</i>	D2182	REV. C
DATE Jan. 6, 1995		TITLE RUBBER CUSHION	SHEET 1 OF 1 SCALE
B	97:04:07	ADD MATERIAL SPECIFICATION	
C	97:05:14	ADD HEAT SHRINK	